

Work Order ID 123030

123030

Page 1

Tuesday, July 29, 2014 2:28:47 PM

Item ID: DSI 9363-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 8/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/29/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: J.A Date: 14/07/30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9363	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPDSI 9363	CHG001							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MAY 06 2015

DAS
06
9-89

DAS
27
9-89

MAY 04 2015

DAS
26
9-89

DAS
06
9-89

MAY 06 2015

mk-1 15/03/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123030

Tuesday, July 29, 2014 2:28:47 PM

123030

Page 2

Item ID: DSI 9363-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 8/27/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/29/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI 9363-011 Location: _____ PPP Rev: _____

PP 117759

MAY 07 2015

DAS
06
9:00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

MAY 07 2015

MCS MAY 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 123030

123030

Parent Item: DSI 9363-011

DSI 9363-011

Parent Item Name: Shim

Start Date: 8/27/14

Required Date: 8/29/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-08-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3238-21 Plate		Manufactured	No			120	Each	14.0000	6	6		DAS 27 9-89	DAS 26 9-89

DAS
06
9-89

Location
ST030
66534
81164

Loc Qty
14
2
12

Loc Code

B127640

D3238-23
Plate

Manufactured No

120

Each

4.0000

2

2

DAS
27
9-89

DAS
26
9-89

Location
ST030
76159

Loc Qty
4
4

Loc Code

B122936

D3238-25
Plate

Manufactured No

120

Each

4.0000

4

4

DAS
27
9-89

DAS
26
9-89

Location
ST030
76160

Loc Qty
4
4

Loc Code

B123019
B125280

D3238-31
Plate

Manufactured No

120

Each

4.0000

12

12

DAS
27
9-89

DAS
26
9-89

Location
ST030
86925

Loc Qty
4
4

Loc Code

B127692

68-6
90
DAS

MAY 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 123030

123030

Parent Item: DSI 9363-011

DSI 9363-011

Parent Item Name: Shim

Start Date: 8/27/14

Required Date: 8/29/14

Start Qty: 1.00

Required Qty: 1.00

D3238-33

Manufactured No

120

Each

4.0000

4 4

~~*D3238-33*~~

Plate

DAS
36
9-89

Location

ST031

50247

Loc Qty

4

4

Loc Code

B123267

4

**

DAS
27
9-89

DAS
26
9-89

D3238-35

Manufactured No

120

Each

19.0000

8 8

~~*D3238-35*~~

Plate

DAS
36
9-89

Location

ST031

86933

B42230

Loc Qty

19

5

14

Loc Code

B123268
B127930

4/19

**

DAS
27
9-89

DAS
26
9-89

MAY 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. DSI 9363	REV. A SHEET 1 OF 1
DATE 07.01.19		TITLE SHIM KIT	SCALE NTS
A	07.01.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-694 REV. B AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D412-694 REV. 1
REF. CANADIAN STC: SH05-10
REF. FAA STC: SR02086NY

J.A. 14/07/30

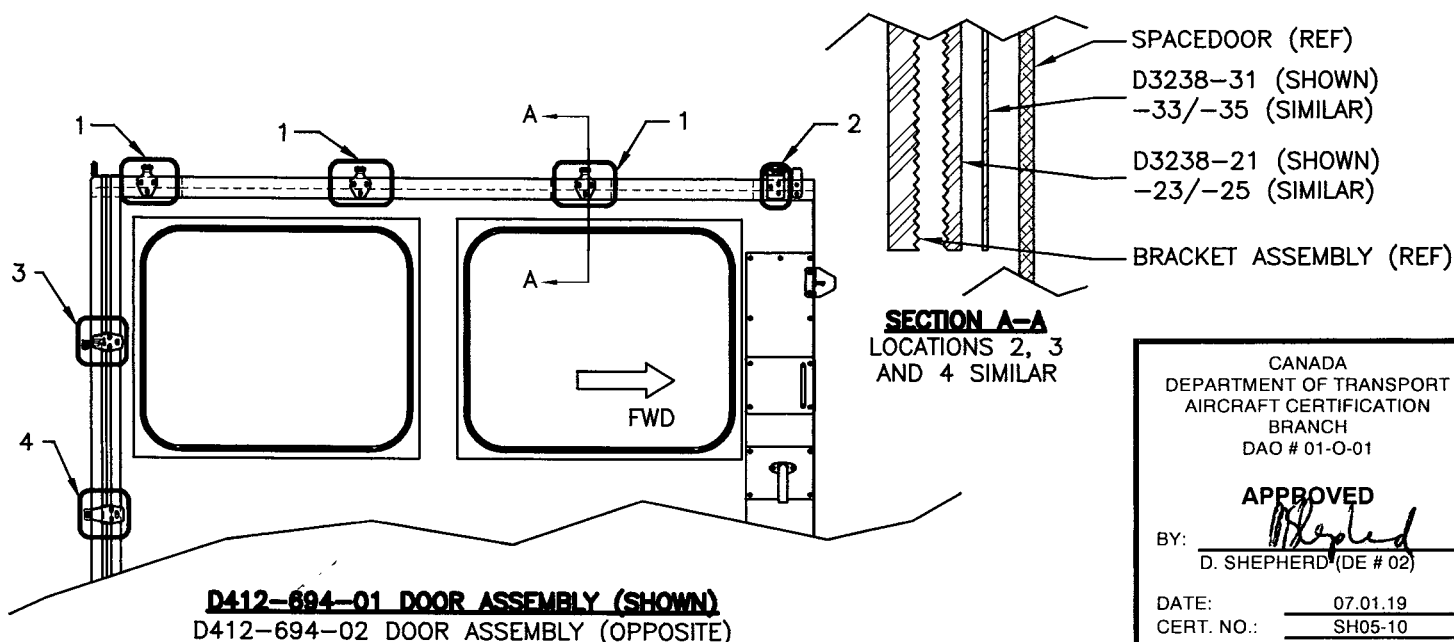
123030

Dart has created the optional DSI-9363-011 Shim Kit that may be installed between the D3121-041/-043/-044, D3183-041/-042 and D3137-041 Bracket Assemblies and the Spacedoor™ to improve grip between the Bracket Assemblies and the Spacedoor™. This kit may be installed as a replacement for or in addition to the AN960JD10 Washers and/or the D3090-1/-3 Shims used to shim the Bracket Assemblies as described in the Installation Instructions.

The serrated faces of the D3238-21/-23/-25 Plates should be installed against the serrated faces of the Bracket Assemblies to ensure positive locking as shown in **Section A-A**. The D3238-31/-33/-35 Plates, the AN960JD10 Washers and the D3090-1/-3 Shims can be installed as required between the D3238-21/-23/-25 Plates and the Spacedoor™ to achieve good door alignment.

The Table and Figure below show the location, the quantity and the part number of each Plate and the corresponding Bracket Assemblies on the Spacedoor™.

Qty	Part Number	Description	Used to Shim Bracket Assembly P/Ns	Location
X	DSI-9363-011	SHIM KIT		
6	D3238-21	PLATE	D3121-041	1
12	D3238-31	PLATE	D3121-041	1
2	D3238-23	PLATE	D3121-043/-044	2
4	D3238-33	PLATE	D3121-043/-044	2
4	D3238-25	PLATE	D3183-041/-042, D3137-041	3, 4
8	D3238-35	PLATE	D3183-041/-042, D3137-041	3, 4



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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. DSI 9363	REV. A SHEET 1 OF 1
DATE 07.01.19		TITLE SHIM KIT	SCALE NTS
A	07.01.19	NEW ISSUE	

DART SERVICE INSTRUCTION

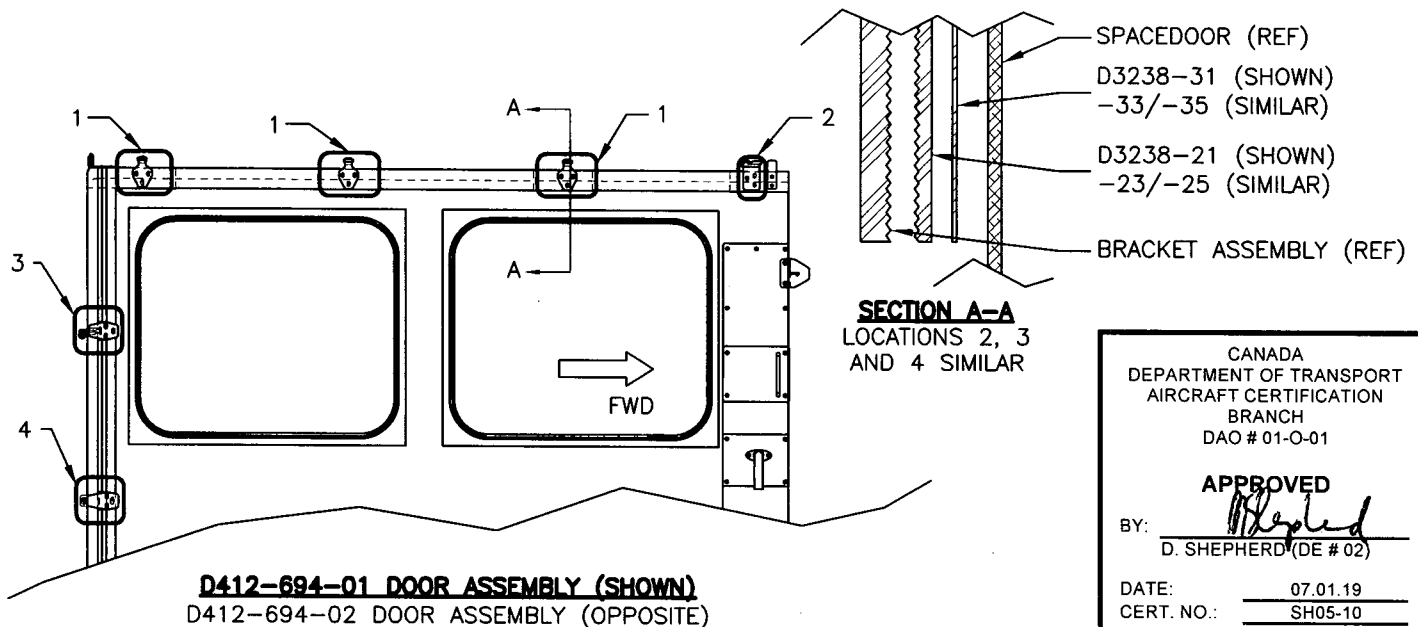
TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-694 REV. B AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D412-694 REV. 1
REF. CANADIAN STC: SH05-10
REF. FAA STC: SR02086NY

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Qty	Part Number	Description	Used to Shim Bracket Assembly P/Ns	Location
X	DSI-9363-011	SHIM KIT		
6	D3238-21	PLATE	D3121-041	1
12	D3238-31	PLATE	D3121-041	1
2	D3238-23	PLATE	D3121-043/-044	2
4	D3238-33	PLATE	D3121-043/-044	2
4	D3238-25	PLATE	D3183-041/-042, D3137-041	3, 4
8	D3238-35	PLATE	D3183-041/-042, D3137-041	3, 4



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: **D. Shepherd**
D. SHEPHERD (DE # 02)

DATE: 07.01.19
CERT. NO.: SH05-10
ISSUE NO.: 1

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